

Date: Friday, 1/27/2006 7:54:21 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER
<b>Job Number</b> : 25635	
<b>Estimate Number</b> : 12105	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D32011
<b>This Issue</b> : 1/27/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3201 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : N/A	<b>Material</b> : MULTIPLY BY 10
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 2/15/2006 <b>Qty:</b> 30 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : [Signature] 06.01.27	
<b>Comment</b> : Est Rev:A Removed from 9 Digit 06-01-25 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 0.2898 sf(s)/Unit Total: 7.2450 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040)  
 Identify for D3201-1  
 Batch: M19295

ml 06/02/24 30

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Cut blank: 8.030" x 4.950"

ml 06/02/24 36

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine D3201-1 as per Folio FA337 and Dwg D3201 Stack of 10 Identify as D3201-1 ml 06/02/24 30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/24 30

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 06.02.24 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/01

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 1/27/2006 7:54:22 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25635

Part Number: D32011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

SAD 06/02/27 30

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/27 30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-02-28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5413

06/2/28 (30)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/01

Job Completion



06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

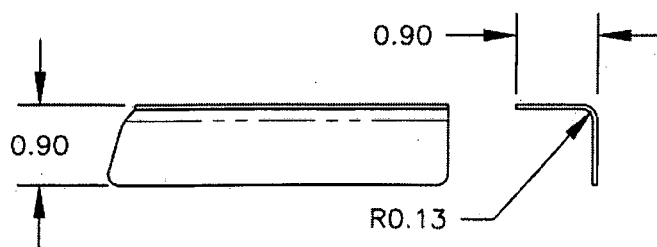
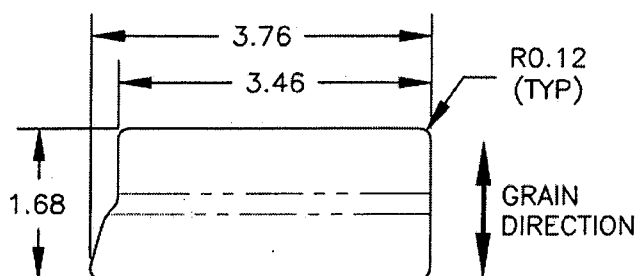
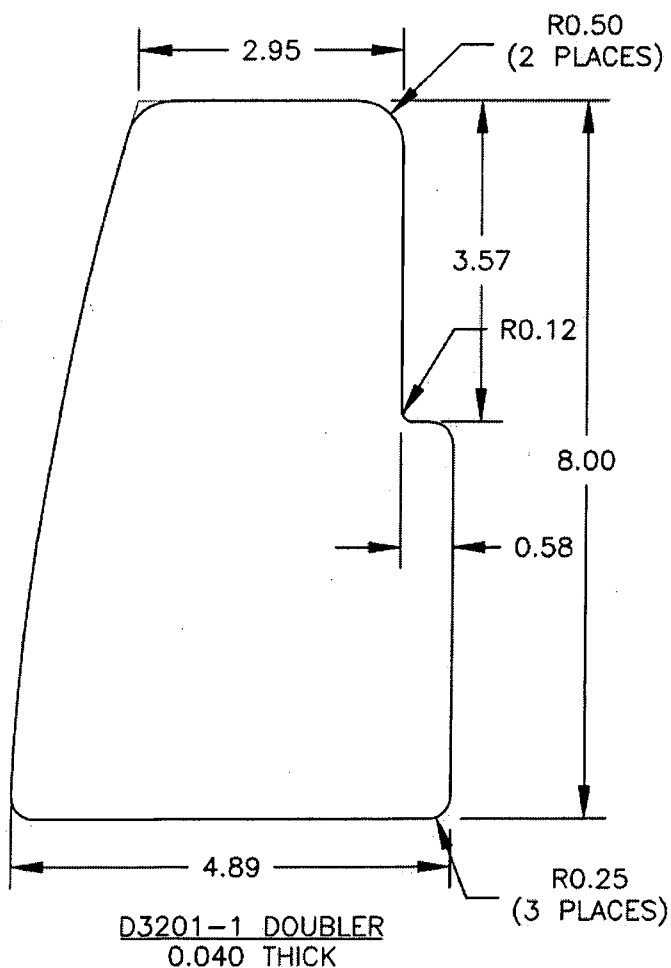
NOTE: Date & initial all entries





DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3201
DATE	03.11.03	TITLE	DOUBLER	REV. B SHEET 1 OF 1 SCALE 1:2
A	03.08.07	NEW ISSUE		
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4		

RELEASED  
03.11.14



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25635

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